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4310 Andre Street, Midland, MI 48642 (US). **VARJIAN, Richard, D.** [US/US]; 6020 Loundonberrie Court, Midland, MI 48640 (US). **WHITE, Jerry, E.** [US/US]; 418 Huckleberry Drive, Lake Jackson, TX 77566 (US).

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(74) Agent: **RUHR, Paula, Sanders**; The Dow Chemical Company, Intellectual Property, P.O. Box 1967, Midland, MI 48641-1967 (US).

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(71) Applicant (*for all designated States except US*): **DOW GLOBAL TECHNOLOGIES INC.** [US/US]; Washington Street, 1790 Building, Midland, MI 48674 (US).

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(72) Inventors; and

(75) Inventors/Applicants (*for US only*): **LYSENKO, Zenon** [CA/US]; 214 W. Meadowbrook Drive, Midland, MI 48640 (US). **MAUGHON, Bob, R.** [US/US]; 601 West Main Street, Midland, MI 48640 (US). **BICERANO, Jozef** [US/US]; 1208 Wildwood Street, Midland, MI 48642 (US). **BURDETT, Kenneth, A.** [US/US]; 2110 Springwood Drive, Midland, MI 48640 (US). **CHRISTENSON, Christopher, P.** [US/US]; 5255 South Hunter, Beaverton, MI 48612 (US). **CUMMINS, Clark, H.** [US/US]; 4317 Washington Street, Midland, MI 48642 (US). **DETTLOFF, Marvin, L.** [US/US]; 205 Basswood, Lake Jackson, TX 77566 (US). **MAHER, John, Michael** [US/US]; 1113 Highland Road, Charleston, WV 25302 (US). **SCHROCK, Alan, K.** [US/US]; 3009 Scarborough Lane, Midland, MI 48640 (US). **THOMAS, P.J.** [US/US];

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(54) Title: INTERGRATED CHEMICAL PROCESSES FOR INDUSTRIAL UTILIZATION OF SEED OILS

(57) Abstract: Integrated processes of preparing industrial chemicals starting from seed oil feedstock compositions containing one or more unsaturated fatty acids or unsaturated fatty acid esters, which are essentially free of metathesis catalyst poisons, particularly hydroperoxides; metathesis of the feedstock composition with a lower olefin, such as ethylene, to form a reduced chain olefin, preferably, a reduced chain  $\alpha$ -olefin, and a reduced chain unsaturated acid or ester, preferably, a reduced chain  $\alpha,\omega$ -unsaturated acid or ester. The reduced chain unsaturated acid or ester may be (trans)esterified to form a polyester polyolefin, which may be epoxidized to form a polyester polyepoxide. The reduced chain unsaturated acid or ester may be hydroformylated with reduction to produce an  $\alpha,\omega$ -hydroxy acid or  $\alpha,\omega$ -hydroxy ester, which may be (trans)esterified with a polyol to form an  $\alpha,\omega$ -polyester polyol. Alternatively, the reduced chain unsaturated acid or ester may be hydroformylated with reductive amination to produce an  $\alpha,\omega$ -amino acid or  $\alpha,\omega$ -amino ester, which may be (trans)esterified to form an  $\alpha,\omega$ -polyester polyamine.

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